



Dart Aerospace Ltd.
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Canada

Tel (613) 632-5200

D5489-045

Job Sheet 171086

Part No: D5489-045

Job Qty: 1 ea

Part Name: Wearplate Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 1/26/18

Job Tracking No:

Created By: Jason Leroux

Description:

Due Date: 1/29/18

Type: SOLD

Note: URF17-729 IPP REV:A 17.11.03 AS PER DWG REV.A DD VERF:JFS

Ship Via:

POSITIVE RECALL

EFFECTIVE 17/01/29 AUTH SAJ

RELEASED PD DATE 18-01-21

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		1/26/18	0.00	0.00	Start Up Waterjet		12 18/01/29
100	Waterjet	4 pcs		1/26/18	0.00	3.62	Waterjet1		12 18/01/29
110	QC	4 pcs		1/26/18	0.00	0.00	QC2 Waterjet-4		12 18/01/29
120	QC	4 pcs		1/26/18	0.00	0.00	QC8-6		2B
130	Brake NC	4 pcs		1/27/18	0.00	2.39	Brake NC 1		SAJ
140	QC	4 pcs		1/27/18	0.00	0.00	QC5		EC
150	Autoweld 1	4 pcs		1/27/18	0.00	4.47	Automated welding		SAJ
160	QC	4 pcs		1/27/18	0.00	0.00	QC10		SAJ
170	QC	4 pcs		1/27/18	0.00	0.00	QC5		SAJ
180	HandFinish	4 pcs		1/29/18	0.00	1.33	HandFinish4		17-1-30
190	QC	4 pcs		1/29/18	0.00	0.00	QC3		PD 18-01-30
200	Packaging	4 pcs		1/29/18	0.00	0.00	Packaging3-2		PD 18-01-31
210	QC21-SA	4 Ea		1/29/18	0.00	0.00	QC21		PD 18-01-31

Part Op 100 - 1-Cut as per Dwg (D5489-5) Dwg Rev: A Prog Rev: A 2-Debur if necessary

Descriptions: 150 - ***SEE NOTE 8,9 FOR SURFACE BUILDUP*** 1- WELD AS PER DWG AND QSI004 4.5 FOR AUTOMATED WELDING USE 8259 HARDCOAT BATCH: 5024335

180 - COAT ENTIRE TOP (CONCAVE) SURFACE WITH ROCKGUARD AS PER DWG AND PER QSI005 A/R

ROCKGUARD BATCH: 138714 exp. 12/18

200 - LOCATION : FP002

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	8 sf (2 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S16GA	8	127	0

Part Specifications

Specifications could not be found.

DART
AEROSPACE
S036719



Wearplate Assembly

PART NO: D5489-045
Original Serial #: S036719
Revision:
Operation:
Change No:

Start up Operation 01/29/18

Job No: 171086

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DQA: _____ Date: _____

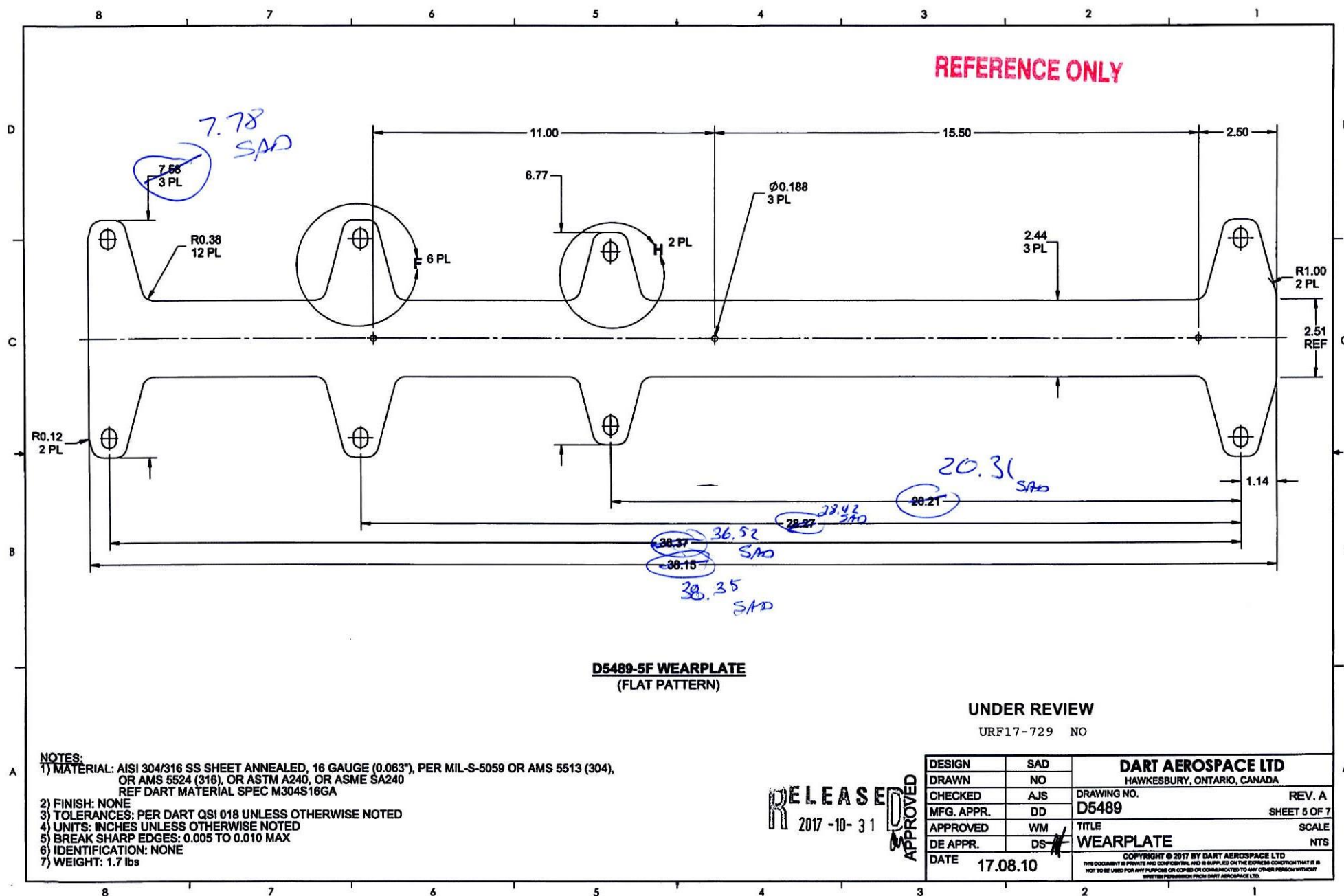
QA Closed: **DAS 53** Date: **APR 25 2018**Work Order update only ☒

Work Order: 171086	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS				
Part No. 05489-045		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☒	
NCR No. 18-6838		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
		Large Fab ☐	Composite ☐	Supplier ☐		

Date: **18/1/29** Step #: _____ QTY Effective: **2** **DAS 12 9-89** MRB (QSI042) Approval **DAS 12 9-89 18/1/29**

Description Work Order Deviation Tooling for wecrplates is not finalized. Weecrplates will be cut and bent to fit skidtube. Flt pattern hole locations shifted to align with skidtube holes. See attached dwg markup for details.	Disposition All weecrplates require a test fit on a skidtube prior to shipment. Test fit acceptable.	Completed By DAS 12 9-89 18/1/31 Lead hand / Supervisor Approval Verification PD 18-0131 QC / QA Coordinator Approval PD 18-0131
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Root Cause			FAULT CATEGORY		
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☒ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ ☒ Instructions Incomplete/Unclear Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					



Non-Conformance Report

Reviewed
DQA:
Date:

Printed on: Tuesday, January 30, 2018

Details

Raised Date 11/8/2017	Status Open	Owner Monterroza, William	Number NCR17-6673
Target Date 2/28/2018	Standard		Severity MINOR
Process Inspection		Audit	
Raised By Person Downing, Eric M	Raised Against (Department or Supplier) Engineering		Fault Category General\Design
Details due to manufacturing issue the following wear plate flat patterns were deviated from drawing.D5489-041, D5489-3, D5489-045 & D5489-047			
Keywords D412-742		Product D412-742	
Document		Root Cause Design	
Closed By	Closed Date	Resolution	

Root Cause

Target Date 11/18/2017	Owner Downing, Eric M	Closed Date 11/8/2017	Closed By Downing, Eric M
Details parts were deviated due to manufacturing of first time parts. correct planning and tooling were not put in place prior to releasing design.			

Actions

Number	Owner	Target Date	Completed Date
Details		Response	

Corrective Action

Target Date 2/28/2018	Owner Monterroza, William	Closed Date	Closed By
Details			

Actions

Number	Owner	Target Date	Completed Date
Details		Response	
1	Duval, David	2/28/2018	
adjust manufacturing process of create tooling.			

Implementing Corrective Action

Target Date	Owner	Closed Date	Closed By
2/28/2018	Monterroza, William		
Details			

Actions

Number	Owner	Target Date	Completed Date
Details		Response	
2	Monterroza, William	11/17/2017	11/9/2017
Implement action to prevent this from reoccurring,Assign Engineering personnel		Assign Steven and Nazim	

Verification & Review

Target Date	Owner	Closed Date	Closed By
2/28/2018	Downing, Eric M		
Details			

Actions

Number	Owner	Target Date	Completed Date
Details		Response	

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☒ Quality ☐ Other ☐			
Date : <u>18-01-30</u>	Step #: <u>120</u>	QTY Effective : <u>(2)</u>		MRB (QSI042) Approval <u>DMS</u> <u>12</u> <u>9-89</u> <u>12/1/30</u>	
Description Work Order Deviation		Disposition			
<u>UCR17-6673</u>		<u>fabricate as per drawing mock up</u>			
		Completed By			
		Lead hand / Supervisor Approval Verification			
		<u>PD 18-01-30</u>			
		QC / QA Coordinator Approval			
		<u>PD 18-01-30</u>			

Root Cause				FAULT CATEGORY			
Environment ☐	Design ☒	Doc/Data ☐	Equip/Tooling ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
				Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
				Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
				Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
				Crushing ☐	Countersink ☐	Off-set ☐	☒ Drawing
				Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
				Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
				Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
				OTHER : _____			